

Date: Friday, 01/08/2008 3:32:32 PM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: TUBE		
Job Number	: 40976					
Estimate Number	: 13373					
P.O. Number	:			Part Number	: D37693	
This Issue	: 01/08/2008		S.O. No.	: D3769 REVA		
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: / /		Type	: SMALL /MED FAB		
Previous Run	: 40315			Drawing Revision	: A	
Written By	:			Material	:	
Checked & Approved By	: <u>JUL 08. 8.05</u>			Due Date	: 21/08/2008	
Comment	: Est Rev:A 08-06-18 rev.A as per dwg DD verified by:EC			Qty:	36	Um: Each

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6T1000W065	6061T6 RD TUBE 1.00 x .065w	
		Comment: Qty.: 1.3283 f(s)/Unit Total : 47.8170 f(s) 6061T6 TUBE (1.00" x 0.65" wall) batch: <u>M108819</u>	<u>SAP</u> <u>08/08/13</u> <u>36</u>
2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1	
		1-cut tube to lenght as per dwg D3769	<u>SAP</u> <u>08/08/14</u> <u>36</u>
		2-drill holes thru on both ends of tube as per dwg D3769	<u>08/08/14</u>
		3-deburr	<u>SAP</u> <u>08/08/15</u> <u>36</u>
3.0	QC5	INSPECT WORK TO CURRENT STEP	
		Comment: INSPECT WORK TO CURRENT STEP	<u>08/08/15</u> <u>36</u>
4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
		Comment: HAND FINISHING RESOURCE #1	
		Chemical Conversion Coat as per QSI 005 4.1	<u>08/08/18</u>
5.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION	
		Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION	<u>08/08/18</u> <u>36X</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 01/08/2008 3:32:32 PM  
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE

Job Number: 40976

Part Number: D37693

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: St 119

MF 08-08-18

7.0 QC21

FINAL INSPECTION/W/O RELEASE



08/08/19 JF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-08-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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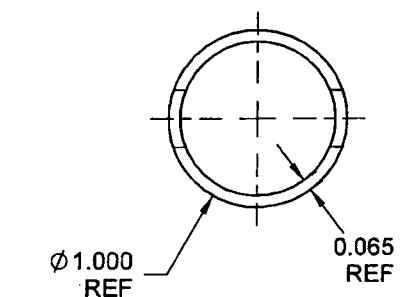
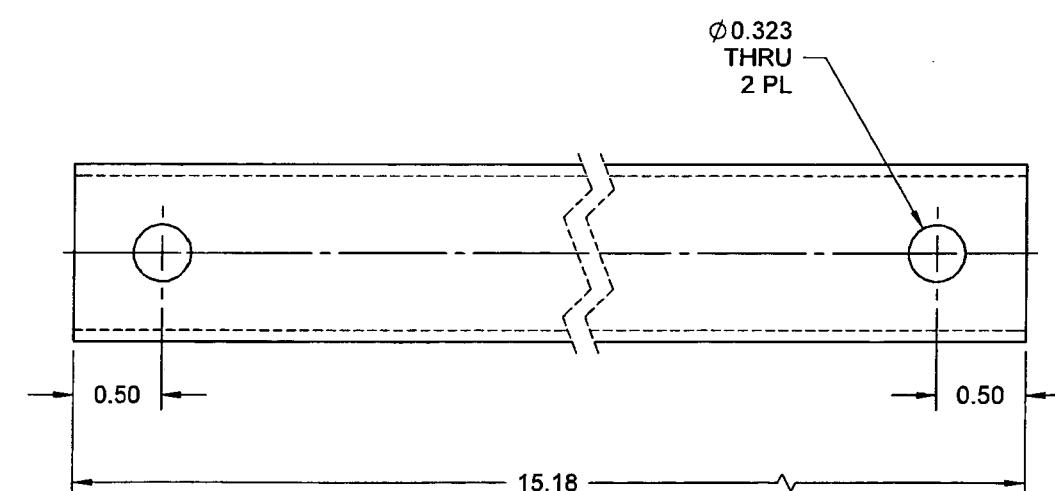
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D3769-3 TUBE

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WORK ORDER  
NO. 40976

DESIGN	HS	<b>DART AEROSPACE LTD</b>
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>PA</i>	DRAWING NO.
MFG. APPR.	<i>PA</i>	D3769
APPROVED	<i>PA</i>	REV. A
DE APPR.	<i>PA</i>	SHEET 3 OF 4
DATE	08.06.04	TITLE
		SCALE
		NTS

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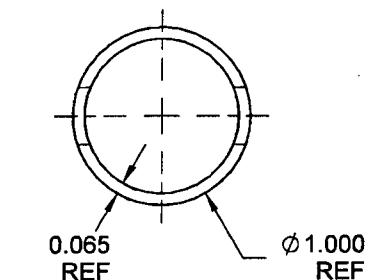
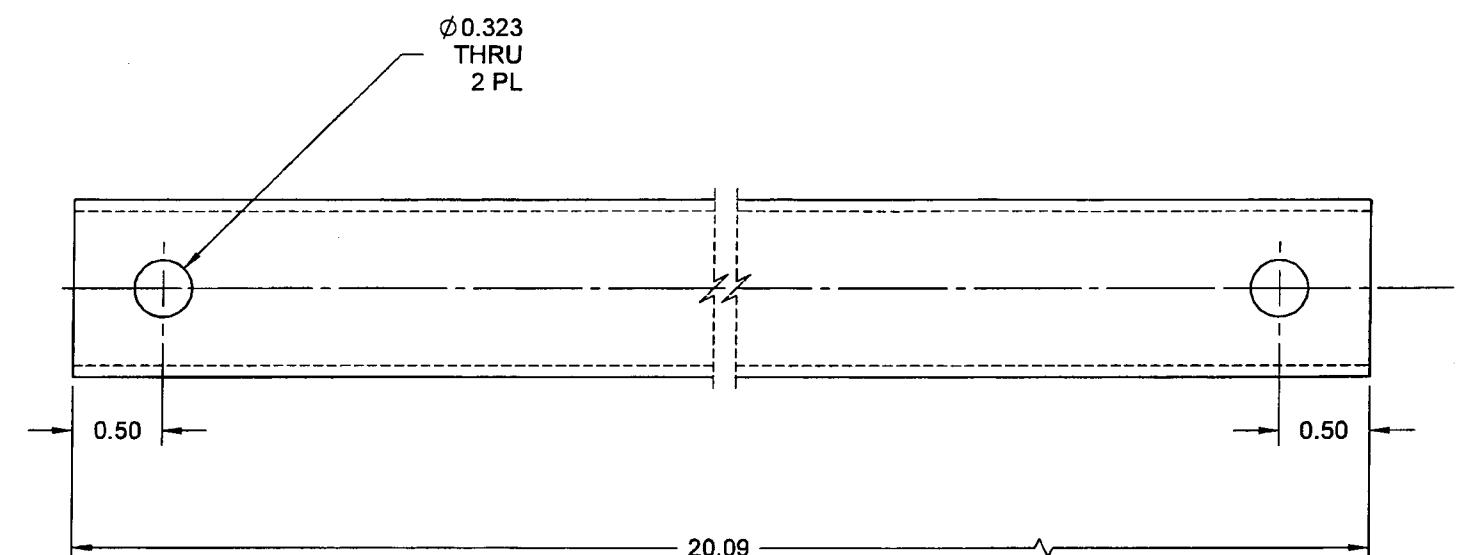
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**D3769-5 TUBE**

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MFG. APPR.	AS	D3769	
APPROVED	MM	REV. A	
DE APPR.	MM	SHEET 4 OF 4	
DATE	08.06.04	TITLE	SCALE
		TUBE	NTS

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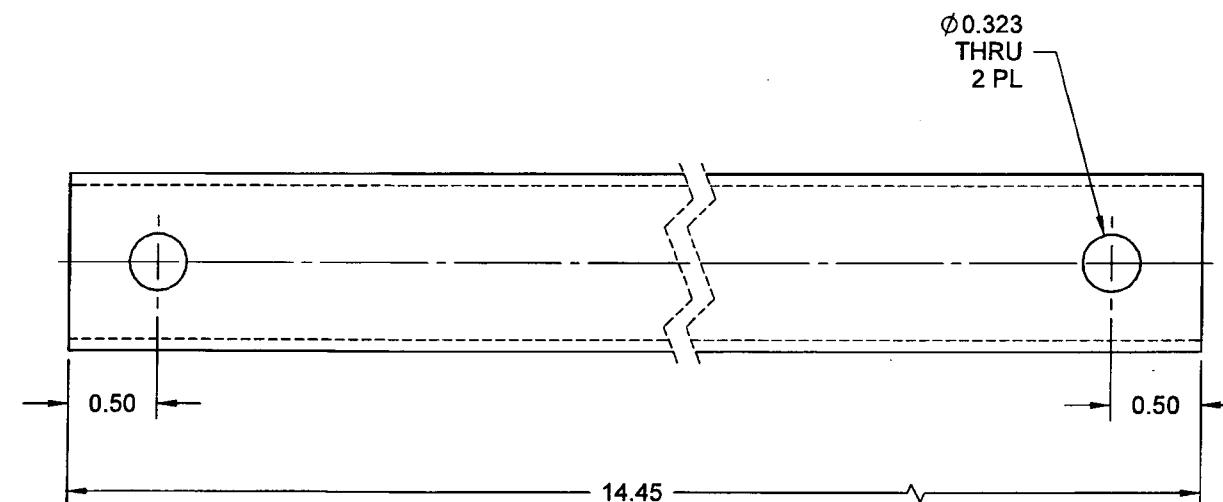
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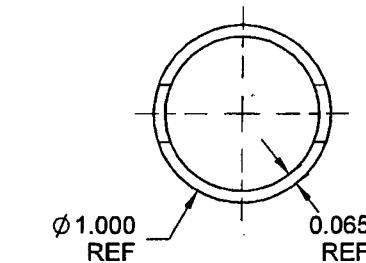
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D3769-1 TUBE



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NO. 40976

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APPROVED	MM	D3769	
DE APPR.	MM	SHEET 2 OF 4	
DATE	08.06.04	TITLE	SCALE
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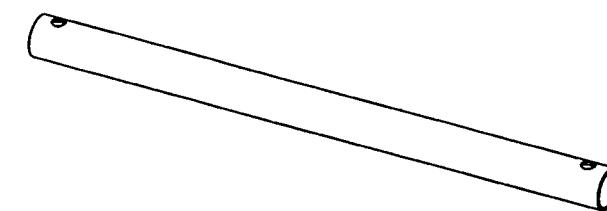
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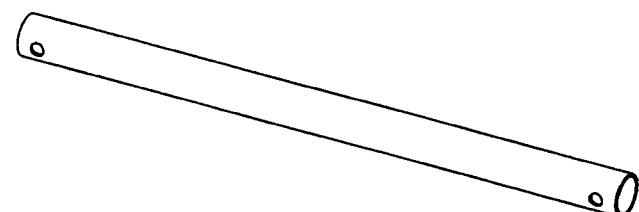
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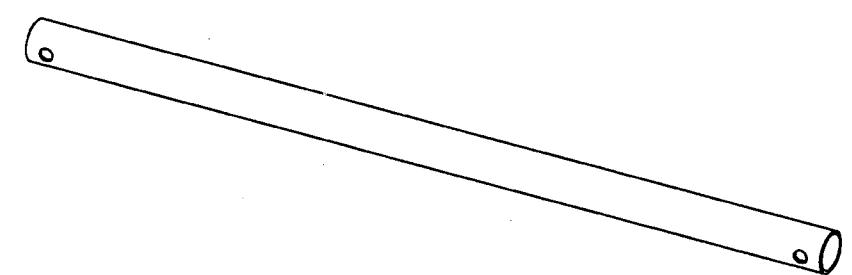
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D3769-1 TUBE



D3769-3 TUBE



D3769-5 TUBE

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NO. **LOT 70**

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08.06.14 14:17

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NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING (1.00" X 0.065" WALL) PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 (REF. DART SPEC. M6061T6T1.000W.065)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3769-1, 0.27 lbs  
D3769-3, 0.28 lbs  
D3769-5, 0.37 lbs

A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION		BY DATE
DESIGN	HS	<b>DART AEROSPACE LTD</b>	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>PL</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>PL</i>	D3769	SHEET 1 OF 4
APPROVED	<i>PL</i>	TITLE	SCALE
DE APPR.	<i>PL</i>	TUBE	NTS
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